












Date: Wednesday, 11/04/2007 8:57:13 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3537-3
Job Number : 31742	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : D35373
This Issue : 11/04/2007 S.O. No. : <i>N/A</i>	Drawing Number : CUSTOM-H/D WELDS
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : <i>N/A</i>
Previous Run : 31741	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 13/04/2007 Qty: 2 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment :	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	HAND FINISHING1 HAND FINISHING RESOURCE #1
	  (2x)
Comment: HAND FINISHING RESOURCE #1 PULL FROM STOCK 2 X D3537-3 B <i>31742 B330758</i> REMOVE PAINT WITH PAINT STRIPPER <i>M.R. 07/04/11</i>	
2.0	D35373 WEARPAD
	  (2x)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) WEARPAD <i>M.R. 07/04/11</i>	
3.0	LARGE FAB 1 LARGE FABRICATION RESOURCE 1
	  (2x)
Comment: LARGE FABRICATION RESOURCE 1 CLEAN PROPERLY WITH A WIRE BRUSH <i>M.R. 07/04/11</i>	
4.0	QC5 INSPECT WORK TO CURRENT STEP
	 
Comment: INSPECT WORK TO CURRENT STEP <i>PD 07-04-12</i>	
5.0	LARGE FAB 1 LARGE FABRICATION RESOURCE 1
	 
Comment: LARGE FABRICATION RESOURCE 1 WELD AS PER DRWG D3537 - MARKED UP BY SERGE HEAVY DUTY HARD FACING A7560/3-2 B <i>102755</i> <i>FC 07/04/12 (2)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: ED Date: 07/04/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3537-3

Job Number: 31742

Part Number: D35373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

07/04/12 (2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

REPAINT GREY SANTEX PER QSI 005

M19720

m-l

07/04/12 (2x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

u 07-04-12

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

RESTOCK USING NEW B/N

USE FOR TUBES - 30967A & 30968A ONLY

u see 30967A 30968A 07-04-13

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-04-13 (2)

Job Completion



u 07-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

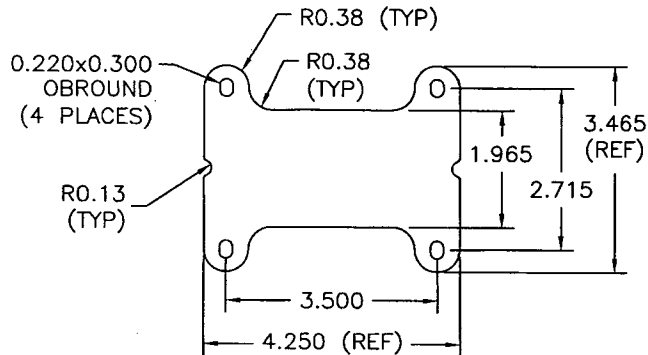
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

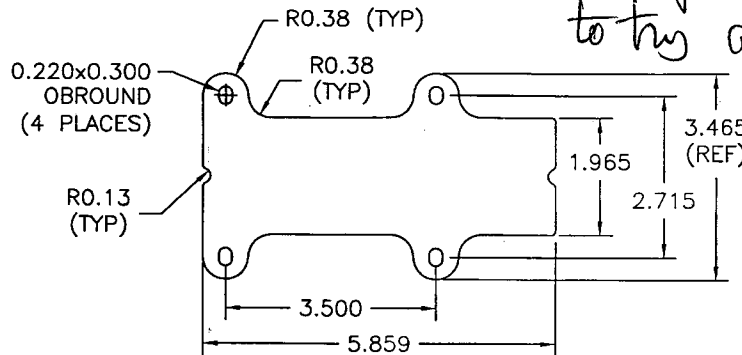
NOTE: Date & initial all entries

30967A  
30968A

### D3537-1F FLAT PATTERN

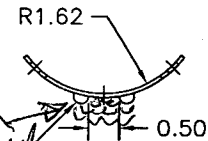


### D3537-3F FLAT PATTERN



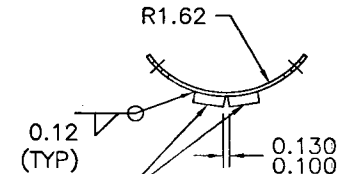
Additional welds  
are for customer  
to try and give  
US a lead back  
as per Bill  
Beckett,  
SAH

### SECTION A-A



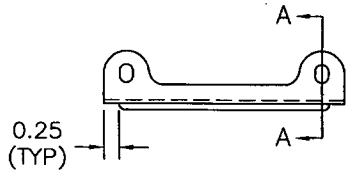
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.063 TO 0.125 THICK

### SECTION B-B

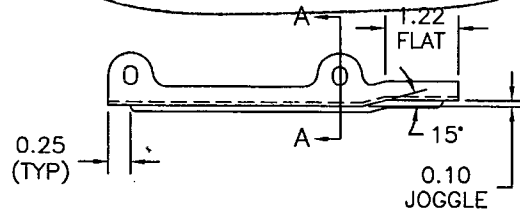


D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

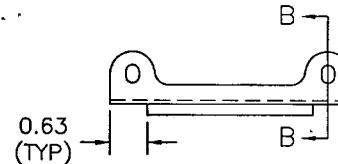
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



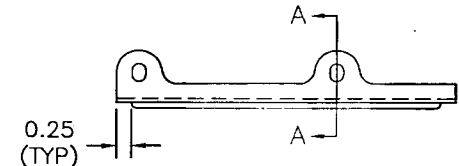
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



RELEASED

07.02.12

### NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE  
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.06	TITLE
		WEARPAD
		DART AEROSPACE USA, INC. PORT HADLOCK, OH
		DRAWING NO. D3537
		REV. A SHEET 1 OF 1
		SCALE 1:2